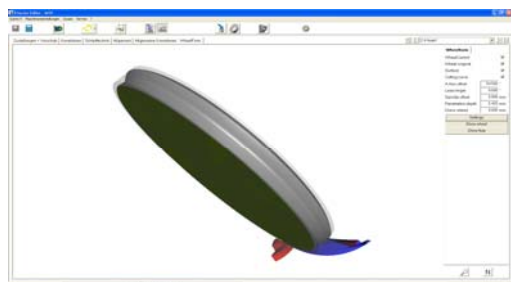



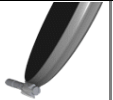

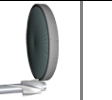




Piloted Counterbore M10

A06-330

The flute and back of the counterbore is ground in one pass with a corresponding formwheel. The form is automatically generated using the Quinto-integrated wheelformcalculation. The pilotoperation grinds 0.5 mm overmeasure in deepcreep spiralgrinding and finishes oscillation in finishing passes of 0.005 mm.



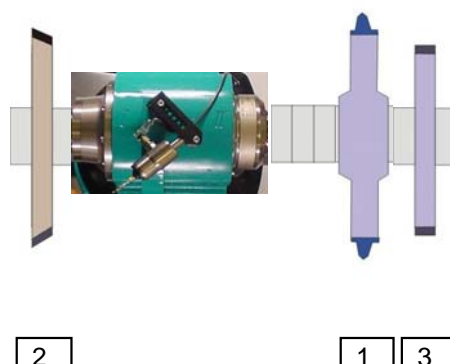
1. Cycletime for Production

Workpiece: Ø 18 mm, Z 3, Length 36 mm, Helix 28° Material HSS					
Operations					
Feed [mm/Min]	2000	80	80	100	9000
Power [kW]		6	1	1	1
Cutting feed [m/s]		32	32	32	
Used wheels					
Grinding time [s]	12	124	44	83	23
Total cycle time	4 Min 45				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø150 B126
2	1V1 Ø150 B126
3	1A1 Ø150 B126



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : GEMINI DMR 26	Coolant:	Synthetic Oil, pressure 16 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Robot, Dressing unit		
Responsible engineer:	OP. 14.4.11		

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